ABSTRACT

In a numerically controlled method of moving an object to be controlled along a predetermined locus, controlling control axes, the locus is made approximate to a spatial polynomial, a polynomial is converted into a polynomial as time function, the polynomial converted as time function is distributed to each control axis, control command in each control axis is produced on the basis of the polynomial distributed to each axis as time function, and the object to be controlled is moved along the locus, controlling each control axis on the basis of the control command. The velocity, the acceleration and the jerk of the object to be controlled can be easily obtained concerning each control axis in advance by differentiating the polynomial expressed by time function. The object to be controlled is controlled so as to move along the locus expressed by the polynomial, feeding irregularity or position shift is reduced and curved face machining at high accuracy is possible.